

Work Order ID 86883

86883

Page 1

July-09-12 9:15:01 AM

Item ID: D2150 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Packer Doubler, Hinge
 Start Date: 7/09/12 Start Qty: 20.00 *20* Cust Item ID:
 Required Date: 7/20/12 Req'd Qty: 20.00 *20* Customer:
 Reference:

Approvals: Process Plan: P Date: 7-20-12 Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2150	Rev A								

100 FLOW WATER JET 0.00
 100
 Waterjet Memo 0.00 20 0 Jm 12-7-23
 FLOW CNC Waterjet 1-Cut as per Dwg D2150 Dwg Rev: A Prog Rev: A 2-
2024 .040 Deburr if necessary

110 QC2- Inspect parts off machine FAI/FAIB 0.00
 110
 QC Memo 0.00 20 0 Jm 12-7-23
 Quality Control

120 QC8- Inspect parts - second check 0.00
 120
 QC Memo 0.00 20 0 Jm 12-7-23
 Quality Control

0.00 Smb / DAS
12-7-24 16 12/12/24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86883

86883

Page 2

July-09-12 9:15:01 AM

Item ID: D2150 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Packer Doubler, Hinge
Start Date: 7/09/12 Start Qty: 20.00 *20* Cust Item ID:
Required Date: 7/20/12 Req'd Qty: 20.00 *20* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130		0.00							
130	Small Fab								
Small Fab	Memo	0.00							
Small Fab	Debur								
140		0.00							
140	Chemical Conversion Coat per QSI005 4.1								
HandFinish	Memo	0.00							
Hand Finishing									
150		0.00							
150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum								
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 9:30								
	FINISH TIME: 10:00								

W121841

3200 F

10:00

20 MG 12-7-25

20X 12/27/27

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86883

86883

Page 3

July-09-12 9:15:01 AM

Item ID: D2150 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Packer Doubler, Hinge
Start Date: 7/09/12 Start Qty: 20.00 *20* Cust Item ID:
Required Date: 7/20/12 Req'd Qty: 20.00 *20* Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							
160									
QC	Memo	0.00				20	0	12/7/27	
Quality Control									
170	Identify as per dwg & Stock Location <u>STC</u>	0.00							
170									
Packaging	Memo	0.00				20			
Packaging									12-7-27
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							12/7/31
Quality Control									

MCJ 12/07/30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-09-12 9:15:01 AM

Page 1

Work Order ID: 86883

Parent Item: D2150

Parent Item Name: Packer Doubler, Hinge

Start Date: 7/09/12

Required Date: 7/20/12

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP C00.11.27Re-format (mpp 2101)EC
IPP Rev:D 06-08-23 Now on Waterjet JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No			100	sf	176.1612	0.025	<u>0.526316</u> 0.55			Jm12-7-83

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
MAT022	176.1611626	
120605	49.6627416	
121197	32.498421	
122136	94	

122136

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

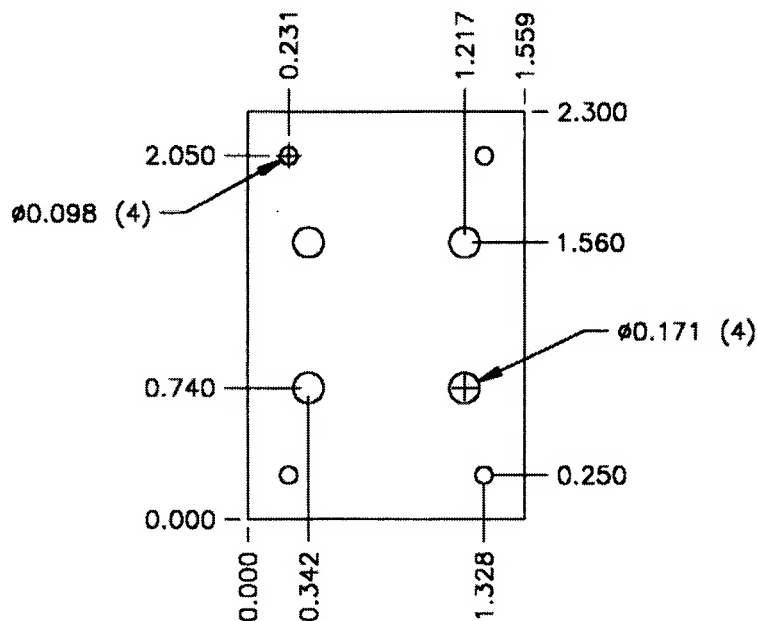
NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	K HAND	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. A
BW	BW	D2150	SHEET 1 OF 1
DATE	TITLE		SCALE
95:05:01	PACKER		1:1

RELEASED
96/06/13 BWS

81883
D12-07-10



MATERIAL: 2024-T3, 0.040 THICK
FINISH: WHITE POWDER COAT HI-GLOSS

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prd Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries